



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
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RB6795635
Job Sheet 196435



Part No: RB6795635

Job Qty: 1 pcs

Part Name: Install/Removal Gas Producer Tail Rotor Bearing Nut Tie Bolt Nut Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/13/19

Job Tracking No:

Due Date: 7/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 16107

Note: DWG RB6795635 Rev D IPP Rev A 17.11.29 New issue DP Verify DD/IPP Rev. B 19.06.13 Drawing Revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	7/8/19		0.00	0.07	Small Fab - 1		MCL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	7/8/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
130	Packaging 3-1 - Stock - B4B	1 pcs	7/8/19		0.00	0.00	QC 5 - 30		AUG 2 1 2019 DAS 40 9-89
							QC 5 - 40		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		DAS 28 7-89
							Packaging 3 - 6 - B4B		



Container No: S207653



Part: RB6795635

Job No: 196435

Serial No/Batch: S207653

Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/21/19

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				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG				1 pcs	7/8/19
				0.00	0.00
				QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	

AUG 23 2019

DAS
77
9-89

Part Op 110 - 1-Assemble as per DWG. See note 8.
 Descriptions: 120 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location: _____ Bag and tag.
 140 - QC21- Final Inspection - Work Order Release

GA139B**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
90692A701	Slotted Spring Pin	1 Ea (1 ea)	110-Small Fab - 1	
RB6795635-1	Sleeve	1 pcs (1 ea)	110-Small Fab - 1	
RB6795635-2	Socket	1 pcs (1 ea)	110-Small Fab - 1	

Job Allocations

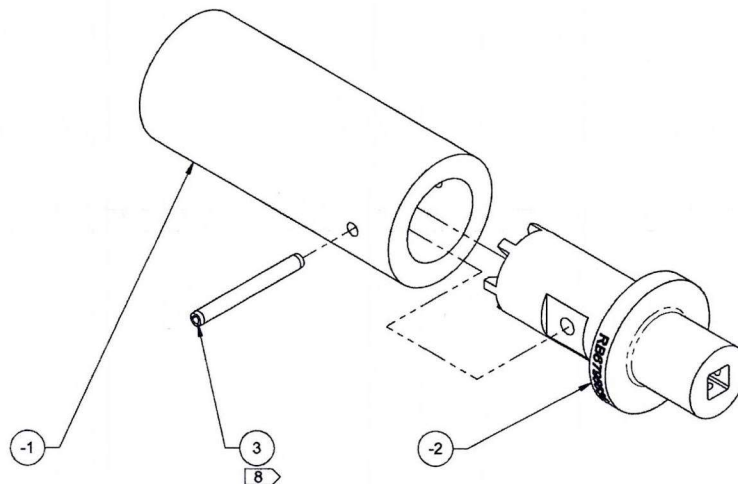
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	90692A701	1	96	0
	RB6795635-1	1	1	0
	RB6795635-2	1	0	0

Part Specifications

Specifications could not be found.

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ITEM #	QTY	PART #	PART TITLE
-1	1	RB6795635-1	SLEEVE
-2	1	RB6795635-2	SOCKET
3	1	McMaster#90692A701 OR EQUIV	ZINC PLATED STEEL SLOTTED SPRING PIN 1/8" DIA. X 1-1/4" LG.

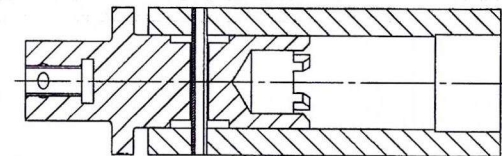
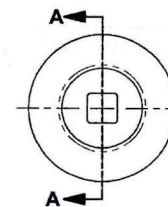


RB6795635 INST/REM GAS PRODUCER T/R BEARING NUT TIE BOLT NUT WRENCH

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) PRESS FIT ITEM 3 WITH ITEM -1 AND ITEM -2
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 19043545
1906-13



SECTION A-A

SEE PREVIOUS PDFs FOR OLDER REVs TEMPLATE UPDATED PER DART HBY STANDARDS ITEM -2 WAS ASSY IS ITEM -2 PART ITEM -2A & -2B DELETED ITEM -1 DIMENSION .437 CHANGED FOR 0.44, DIMENSION 3.000 CHANGED FOR 3.00, DIMENSION (Ø 1.250) CHANGED FOR Ø 1.25, MATERIAL DOM CHANGED FOR 4140 (28-32 RC), ENGRAVING "MADE IN USA" AND S/N REMOVED ITEM -2 DIMENSION .937 CHANGED FOR 0.94, DIMENSION Ø .68 CHANGED FOR Ø 0.680, DIMENSION .501 CHANGED FOR .50 DIMENSION 0.335 MIN ADDED, DIMENSION .500 CHANGED FOR 0.50, MATERIAL 4140/4142 CHANGED FOR 01, HEAT TREAT RC 36-40 CHANGED FOR 48-52 Rc, BLACK OXIDE FINISH ADDED, DIMENSION 0.152 ADDED, DIMENSION 0.290/0.280 ADDED, DIMENSION R0.07 4 PL ADDED.		19-749	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RB6795635 TITLE INST/REM GAS PRODUCER T/R BEARING NUT TIE BOLT NUT WRENCH SCALE NTS	
DRAWN	VM		
CHECKED	KPT		
MFG. APPR.	JFC		
APPROVED		REV. D SHEET 1 OF 3	
DATE	2019-06-12	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					